



Europäisches  
Patentamt

European  
Patent Office

Rec'd PCT/PTO 02 FEB 2005

P-GB2003/003347

Office européen  
des brevets

#3

REC'D 08 SEP 2003

WIPO

PCT

Bescheinigung

Certificate

Attestation

Die angehefteten Unterla-  
gen stimmen mit der  
ursprünglich eingereichten  
Fassung der auf dem näch-  
sten Blatt bezeichneten  
europäischen Patentanmel-  
dung überein.

The attached documents  
are exact copies of the  
European patent application  
described on the following  
page, as originally filed.

Les documents fixés à  
cette attestation sont  
conformes à la version  
initialement déposée de  
la demande de brevet  
européen spécifiée à la  
page suivante.

Patentanmeldung Nr. Patent application No. Demande de brevet n°

02255426.5

**PRIORITY  
DOCUMENT**

SUBMITTED OR TRANSMITTED IN  
COMPLIANCE WITH RULE 17.1(a) OR (b)

Der Präsident des Europäischen Patentamts;  
Im Auftrag

For the President of the European Patent Office

Le Président de l'Office européen des brevets  
p.o.

R C van Dijk

**BEST AVAILABLE COPY**



Anmeldung Nr:  
Application no.: 02255426.5  
Demande no:

Anmeldetag:  
Date of filing: 02.08.02  
Date de dépôt:

Anmelder/Applicant(s)/Demandeur(s):

Ionic Solutions Limited  
P.O. Box 993  
Bradford, BD1 4JX  
GRANDE BRETAGNE  
Cosmetic Rheologies Limited  
P.O. Box 89  
Manchester, M12 6RH  
GRANDE BRETAGNE

Bezeichnung der Erfindung/Title of the invention/Titre de l'invention:  
(Falls die Bezeichnung der Erfindung nicht angegeben ist, siehe Beschreibung.  
If no title is shown please refer to the description.  
Si aucun titre n'est indiqué se référer à la description.)

Polymeric compositions and their production and uses

In Anspruch genommene Priorität(en) / Priority(ies) claimed /Priorité(s)  
revendiquée(s)  
Staat/Tag/Aktenzeichen/State/Date/File no./Pays/Date/Numéro de dépôt:

Internationale Patentklassifikation/International Patent Classification/  
Classification internationale des brevets:

C08J/

Am Anmeldetag benannte Vertragstaaten/Contracting states designated at date of  
filing/Etats contractants désignées lors du dépôt:

AT BE BG CH CY CZ DE DK EE ES FI FR GB GR IE IT LI LU MC NL PT SE SK TR

Ionic Solutions Limited

PRL04418EP

**Polymeric Compositions and their  
Production and Uses**

5 This invention relates to powdered polymer which is soluble or swellable in water to form a gel, and to the production of this polymer.

10 It is conventional practice to thicken an aqueous composition by adding water-soluble or water-swellable thickening polymer to the composition. It is often desirable to provide this polymer in powder form, namely as a dry product in the form of particles, which may be individual primary particles or which may be aggregates of such particles and which disintegrate when mixed into water.

15 Powdered water-soluble or water-swellable polymer particles can be made by various polymerisation processes including bulk polymerisation followed by comminution, solution polymerisation followed by drying (for instance by spray drying), precipitation polymerisation followed by recovery of the precipitate and drying, and reverse phase emulsion polymerisation followed by recovery of the polymer from the emulsion.

20 Each method gives a powdered product having different physical form (such as shape and size) and also having different types and degrees of contamination.

25 The selection of the polymerisation method and the monomers to be polymerised also influences the molecular weight (including the molecular weight distribution) which is conveniently achieved by the polymerisation. For instance some anionic polymers can conveniently be made by methods such as precipitation polymerisation to give polymers having good molecular weight properties and low contamination, but such techniques tend to be less satisfactory for cationic monomers. In order to obtain the optimum molecular weight properties using cationic monomers it is generally preferred to use reverse phase emulsion polymerisation, but this tends to result in powdered

products which are contaminated with materials that reduce the clarity of the final gel.

Clarity of the gel is particularly desirable in personal care compositions such as cosmetic compositions and topical pharmaceutical compositions. The thickening polymer in these frequently is a cationic polymer, for instance as described in US-A-4,806,345 and US-A-5,603,926.

It would therefore be desirable to produce an improved way of making a powdered polymeric product which can give a gel having good clarity, and in particular it would be desirable to provide this where the polymer is a cationic polymer.

---

According to one aspect of the invention, we provide a powdered composition formed of particles, or aggregates of particles, of a water-soluble or water-swellaable polymer wherein the product dissolves or swells in water at a gelling pH to form a gel, and wherein the particles have the characteristic, substantially spherical, structure of polymer particles made by reverse phase emulsion polymerisation, and the composition gives a 0.5% gel in water, wherein the gel has a clarity of at least 90% at 430nm (as explained below).

Whether or not the polymer particles have the characteristic, substantially spherical, structure including shape of particles made by reverse phase emulsion polymerisation can easily be determined by microscopic examination. Particles made by spray drying may be substantially spherical but they can be seen by microscopic examination to be very porous and shell like and so the product includes pieces of fractured shell. Particles made by solution, bulk or precipitation polymerisation all have characteristic, non-spherical, shapes. Particles made by reverse phase emulsion polymerisation have a dry size typically in the range 0.5 to 20 $\mu$ m, often 1 to 10 $\mu$ m, and when examined by a microscope are predominantly solid spheres. For instance with at least 80% of the particles in any particular microscopic image typically are truly

spherical or substantially spherical, although there can be minor amounts of broken, pear-shaped or other deformed solid particles.

5 Normal ways of conducting reverse phase emulsion polymerisation of a monomer result in the particles being contaminated by significant amounts of cloud-forming impurities which were included as essential components in the reverse phase emulsion polymerisation process. For instance it is normal to use a significant amount of  
10 emulsifier in order to stabilise the emulsion initially and it is normal to select a non-aqueous liquid as the continuous phase, and optionally also a polymeric stabiliser, to improve the stability of the emulsion, especially during subsequent evaporation of water from it,  
15 and parts of these remain on the particles.

The powdered products of the invention are preferably free of cloud-forming amounts of polymeric stabiliser, hydrocarbon and emulsifier.

20 As a result of using reverse phase emulsion polymerisation for making the polymer particles, it is easily possible to optimise the eventual viscosifying properties because reverse phase emulsion polymerisation allows this to be done, in accordance with common general knowledge, much more easily than is achievable when using  
25 other types of polymerisation, especially when the polymer is cationic.

According to a second aspect of the invention, we make a powdered composition formed of particles, or aggregates of particles, of a water-soluble or water-swellaable polymer  
30 wherein the product dissolves or swells in water to form a gel, by a method which comprises

forming an emulsion of aqueous monomer in non-aqueous liquid, optionally in the presence of an emulsifier,  
initiating polymerisation and allowing polymerisation  
35 to complete,

distilling water from the emulsion until the emulsion is substantially dry, the distillation being conducted

while maintaining a sufficient amount of the non-aqueous liquid to prevent breakage of the emulsion,

separating the non aqueous liquid from the polymer particles by a process comprising washing the substantially  
5 dry emulsion, or a slurry or cake of dry polymer particles separated from it, with an organic, volatile, solvent which is a solvent for non-aqueous liquid and for the emulsifier (if used) and which does not dissolve or swell the polymer particles and which is substantially miscible with water,  
10 separating the washed polymer particles as a cake or slurry of the particles wetted by the solvent, and  
evaporating the solvent from the cake or slurry and  
thereby providing the powdered composition.

---

The polymer is made by reverse phase emulsion  
15 polymerisation of water soluble or water swellable ethylenically unsaturated monomer or monomer blend. Any of the conventional cationic, non-ionic and anionic ethylenically unsaturated monomers can be used, together with blends of the monomers. The polymer is preferably  
20 cationic and so the monomer or monomer blend which is polymerised preferably contains one or more cationic ethylenically unsaturated monomers, or a blend of such monomer with non-ionic monomer and/or anionic monomer. The amount of cationic monomer is preferably such that the  
25 monomer is predominantly cationic.

Preferred cationic monomers are cationic esters of acrylic or methacrylic acid, preferably a cationic methacrylate. Accordingly, the polymer is generally a  
polymer of 50 to 100 mole percent water soluble cationic  
30 ester of methacrylic acid and 0 to 50 mole percent of other water soluble ethylenically unsaturated monomers. If comonomer is present, it may be non-ionic (for instance acrylamide) or in some instances a minor amount of anionic comonomer can be present.

35 The preferred cationic monomer is an acid addition or quaternary ammonium salt of a dialkylaminoethyl

methacrylate, and is most preferably the methyl chloride quaternary salt of dimethylaminoethyl methacrylate.

5 The polymer can be linear but is usually lightly cross linked and so it is normally formed in the presence of a cross linking agent. As is conventional, this cross linking agent can be a polyethylenically unsaturated material.

10 The preferred polymers are homopolymers of the cationic ester of methacrylic acid, copolymerised with, usually, 0.001 to 0.1 mole percent of a polyethylenically unsaturated cross linking agent such as methylene bis acrylamide or any of the conventional cross linking agents used for making swellable viscosifying polymers.

15 The non-aqueous liquid is preferably volatile and preferably is a hydrocarbon. Preferred hydrocarbons are aliphatic hydrocarbons, preferably branched or linear isoparaffins. They preferably have a boiling point at normal pressure of below 200°C, most preferably in the range 150 to 180°C. Examples are the materials sold under  
20 the trade names Isopar G and Multipar G.

Preferably the continuous phase of the emulsion consists substantially only of the hydrocarbon or other non-aqueous liquid. The continuous phase preferably is wholly or substantially free of non-volatile non-aqueous  
25 liquid and/or polymeric stabiliser (both of which are conventional in prior processes).

It is usually desirable to include some emulsifier in order to facilitate formation and stability of the emulsion but in the invention the amount of stabiliser preferably is  
30 minimised by conducting the polymerisation on a more dilute solution of monomer than is conventional in reverse phase polymerisation for making the relevant polymers. Thus conventional processes usually have a monomer concentration of above about 72% (monomer based on monomer plus water)  
35 and with the total amount of water in the emulsion, based on the total weight of the emulsion, often being around 15%. In the invention, however, we prefer to use more

water in the emulsion so that the aqueous monomer solution is more dilute.

Typically the concentration of monomer is below 70% and is usually in the range 50 to 68% (based on monomer plus water). The amount of water, based on the total weight of the emulsion, is now usually in the range 20 to 40%, preferably 22 to 30%. Typically the amount of polymer is 35 to 55%, often around 40 or 45% to 50%, and the amount of the volatile non-aqueous liquid is generally 20 to 40%, often around 25 to 35%.

With such amounts, and with routine selection of the volatile hydrocarbon or other non-aqueous liquid, it is possible to minimise, and sometimes even to eliminate, the emulsifier while maintaining emulsion stability. If emulsifier is being used then it can be any of the conventional emulsifiers for water-in-oil polymerisation, typically emulsifiers having HLB of 3.5 to 6. A preferred material is the material commercially available under the trade mark Span 80. Other suitable emulsifiers include glyceryl mono-oleate and sorbitan sesqui-oleate.

The amount of emulsifier is usually from 0.1 to 1, 1.5 or 2% based on the weight of emulsion or 0.2 to 2, 3 or sometimes 4% based on the weight of monomer.

The emulsion may be formed in conventional manner and polymerisation may be achieved by purging with nitrogen gas and adding initiator, usually throughout the whole period, or most of the polymerisation reaction. In order to facilitate rapid distribution of the initiator throughout the emulsion, some or all of the initiator is preferably added as an emulsion or solution in non-aqueous liquid. Thermal initiator can be used as part or all of the initiator system but it is often adequate to rely on a redox system, for instance with sodium metabisulphite being added as an emulsion in non-aqueous liquid and t-butyl hydroperoxide or other redox couple being added as a solution in non-aqueous liquid. The rate of addition and the duration of addition is conducted in conventional



manner and the progress of the polymerisation is monitored in conventional manner.

When it is judged that the polymerisation has gone to completion, the emulsion is dried by distillation of the aqueous phase from it. Distillation is normally conducted under reduced pressure with reflux of the non-aqueous liquid while the water is removed.

It is necessary to ensure that the emulsion does not break during this process, i.e., it must not break to an extent sufficient to cause serious congealing of the polymer particles. It is often desirable to add an additional amount of the non-aqueous liquid prior to or during this distillation stage so as to reduce the risk of breakage of the emulsion by maintaining the liquid content of the emulsion substantially constant. For instance the amount of additional non-aqueous liquid which is added may be 0.2 to 1.5 times, often around 0.5 to 1 times, the amount of water which is being removed.

The distillation is conducted until the water removal has dropped to a very low rate, preferably near zero. This occurs when the emulsion is substantially dry, for instance having a water content (based on the weight of polymer) of below 10% and usually below 5% by weight.

The dry polymer particles are then separated from the non-aqueous liquid by a process comprising washing the substantially dry polymer particles with an appropriate volatile solvent. The solvent may be added to the entire mixture of non-aqueous liquid and polymer particles (so that the entire emulsion is washed) or some of the non-aqueous liquid may be separated, for instance by filtration or centrifugation, before the washing to form a slurry or cake, and it may be this slurry or cake which is washed.

The amount of the solvent is often such that the percentage of polymer, based on polymer and solvent, is 1 to 50%, often 1 to 15%, preferably 2 to 10%.

After the washing, the polymer particles are separated from the solvent, again usually by a filtration or

centrifugation or other physical separation step, to form a cake or slurry. The particles can be washed again with more solvent if required. Preferably the content of polymer in the final cake or slurry of particles and  
5 solvent is at least 30%, preferably at least 45%, and most preferably at least 50, 55 or 60%, up to 70% or more.

Residual solvent is then evaporated from the resultant cake or slurry of polymer particles, for instance by oven or other warm air drying so as to provide the desired dry  
10 product.

In general, clarity improves as the amount of solvent used for the washing is increased and as the amount of solvent which has to be evaporated is reduced.

---

The solvent which is used for the washing must be a  
15 solvent for the non-aqueous liquid of the continuous phase of the emulsion in order that the solvent washes that liquid away from the particles. If emulsifier was used, it must also be a solvent for the emulsifier, so as to wash that away from the particles. Whether or not any  
20 particular solvent is a good solvent for any particular emulsifier can be checked by a simple routine test. The solvent must not dissolve or swell the polymer particles.

The solvent must be sufficiently volatile that it can be conveniently evaporated by warm air or other suitable  
25 drying technique. Preferably the solvent is sufficiently volatile that there is no risk of any traces of solvent remaining on the particles after drying. However, it is, in any event, desirable that the solvent is substantially fully miscible with water so that any traces of solvent on  
30 the particles will not cause cloudiness of the final gel.

The solvent is usually a polar solvent. Preferably it is a C1-4 alcohol or ketone. Methanol and ethanol may, however, cause some swelling of some potential cationic polymers and so is not preferred for use with those, and  
35 acetone tends to be an inadequate solvent for some grades of Span 80 or other emulsifier and so is not preferred for

these. The preferred solvent is generally isopropyl alcohol.

5 In some instance it is desirable to include with the solvent a small amount of a water-miscible cosolvent for any emulsifier. Suitable cosolvents are emulsifiers having a long ethoxy chain whereby the hydrophilic component promotes dissolution of the emulsifier into the volatile solvent. An example is ethoxylated sorbitan monolaurate, typically having more than ten ethoxy groups, preferably 10 twenty ethoxy groups. The addition of a cosolvent in this manner can help to provide final "polishing" of the clarity of the gel. Alternatively the cosolvent emulsifier may be incorporated into the gel formed from the dry product.

15 The dry product, consisting of the particles or aggregates of particles, can then be incorporated into a personal care or other composition as a viscosifier in conventional manner. The composition should be formulated to have a pH at which the polymer gels to form a gel of the dissolved or swollen polymer particles, i.e., the gelling 20 pH. For cationic polymers, the gelling pH can be as low as 2.5. Although the composition often has pH below 7, for instance 4.5 to 6.8, stable gels of cationic polymers can be formed in the invention having pH values higher than this, for instance up to 9 or even 10 or 10.5, when using 25 cationic polymers in accordance with the invention. Naturally the optimum pH depends on the monomers which are used and on the other components of the composition.

30 As a result of providing a powdered composition formed of particles of water-soluble or water-swellaable polymer free of cloud-forming amounts of polymeric stabiliser, hydrocarbon or other non-aqueous liquid, and emulsifier, despite having been made by reverse phase polymerisation, the powdered composition gives a clear gel in water. In particular, the process of the invention can easily be 35 conducted so that the composition gives a gel which has a clarity of at least 85% and preferably at least 90%, and most preferably at least 93% or, especially, at least 95%.

In this specification, all clarity values are determined by the following protocol, which is designed for determining the clarity of a gel formed by dissolving cationic polymer in deionised water, without any deliberate pH adjustment. If the relevant polymer does not dissolve or swell to an optimum extent when dissolved merely in water, then some pH adjustment may be applied, for instance as described in the Noveon Standard Test Procedure 485-D September 1993. The preferred protocol, however, is as follows:-

1. The clarity measurement is performed on a 0.5% solution of polymer in deionised water, using a Colorimeter such as a Brinkmann Probe Colorimeter Model PC-801.
2. The polymer is dried at 80°C for 1 hour.
3. The polymer is allowed to cool and 1.0000g +/-0.002 weigh accurately on an analytical balance into a weigh boat.
4. 199g +/-0.02g deionised water is weighed into a 250ml plastic beaker.
5. The beaker is clamped in place and stirred using a 50mm radial flow impeller, placed near the bottom of the beaker.
6. The polymer is added slowly to the deionised water to avoid clumping since the presence of agglomerated particles would interfere.
7. After the solution starts to thicken the stirrer speed is increased to 2000rpm for 5 minutes to ensure full hydration.
8. Using a spatula, transfer a portion of the solution to a 50mL centrifuge tube.
9. Place the tube in the centrifuge and spin for five minutes at the maximum speed setting. Centrifugation is for elimination of air bubbles since these would interfere.
10. Turn the colorimeter to %T and place in 430mm filter and allow a five minute warm-up period.
11. Fill a 1cm cuvette with deionised water and adjust the 100% T Coarse Control Knob until the reading indicates

100.0% or very close. Use the Fine Control to obtain an exact reading of 100.0%.

12. Using a spatula, transfer a portion of the solution to a 2cm cuvette avoiding air entrapment.

5 13. The % Transmission (or Clarity) is read directly from the instrument.

The following is an example of the invention.

10 An emulsion was formed of 6673g of a 75% aqueous solution of the MeCl quaternary salt of dimethylaminoethyl methacrylate, 12.8g citric acid, 1043g deionised water, 11.4g Tetralon B and 0.693g methylene bis acrylamide in 3227g Multipar G containing 80.6g Span 80 as emulsifier. The emulsion was made by forming the aqueous phase and the oil phase separately and then homogenising the oil phase 15 into the aqueous phase for 20 minutes using a Silverson with cooling to keep the temperature at or below 20°C. The emulsion was then transferred to a conventional polymerisation pot, degassed for 30 minutes and held under nitrogen. A 0.5% emulsion of SMBS in Isopar G and a 0.5% 20 solution of TBHP in Isopar G were fed into the emulsion at 100ppm per hour, and the temperature was monitored every 60 seconds to ensure that the polymerisation was continuing satisfactorily.

25 After the completion of the full exotherm was observed, the initiator feeds were continued for a further 20 minutes. They were then terminated, and the reaction mixture was left stirring for a further 20 minutes to allow polymerisation to complete.

30 200g of the product was removed from the vessel and was diluted with 50g Isopar and was then subjected to distillation using a rotary evaporator under full vacuum at a temperature ranging between 25 and 80°C until the final product was a dry emulsion of the dry polymer particles in hydrocarbon.

35 Isopropyl alcohol in an amount of 95% based on the weight of polymer and isopropyl alcohol was then mixed with the product so as to wash the polymer particles. The

resultant mixture was then separated by decantation and centrifugation and the resultant cake had a polymer content of 61%. The residual solvent was evaporated from the cake in an oven at less than 60°C until a dry weight (1gm for 1  
5 hour at 110°C) of at least 90% is achieved (for instance at 40°C for 2 days).

The resultant product consisted of substantially spherical solid particles, and easily disintegratable aggregates of these, which were easily distributed into  
10 water to give a clear gel having a clarity of 98%.

In other tests, a clarity of 99% was obtained when the amount of isopropyl alcohol was 98.75% and the resultant cake or slurry was concentrated to 58% polymer before the  
drying, but a clarity of only 75% was obtained when the  
15 amount of isopropyl alcohol was 95% but the resultant cake or slurry only contained 46.5% polymer prior to the final evaporation of solvent in the oven. In another example a clarity of 95% was achieved when the amount of isopropyl alcohol was 97.5% and the slurry or cake, before final  
20 evaporation in the oven, had a polymer content of 42.3%.

In another process where the clarity, when using isopropyl alcohol alone, was 88%, a clarity value of above 95% was achieved by including with the solvent 1% of 20 mole ethoxylate of sorbitan monolaurate.

CLAIMS

1. A process of making a dry product formed of particles, or aggregates of particles of a polymer wherein the product can dissolve or swell in water to form a clear gel, the process comprising
- 5 forming an emulsion of aqueous ethylenically unsaturated cationic monomer in non-aqueous liquid optionally in the presence of an emulsifier, initiating polymerisation and allowing polymerisation
- 10 to complete, distilling water from the emulsion until the emulsion is substantially dry, the distillation being conducted while maintaining a sufficient amount of non-aqueous liquid in the emulsion to prevent breakage of the emulsion,
- 15 separating the non-aqueous liquid from the polymer particles by a process comprising washing the substantially dry emulsion, or a slurry or cake of dry polymer particles separated from it, with a volatile organic solvent which is a solvent for the non-aqueous liquid and for the emulsifier
- 20 (if used) and which does not dissolve or swell the polymer particles and which is substantially miscible with water, separating the washed polymer particles as a cake or slurry of the polymer particles wetted by the solvent, and evaporating the solvent from the cake or slurry
- 25 and thereby providing the dry polymer particles or aggregates thereof.
2. A process according to claim 1 in which volatile non-aqueous liquid is added to the emulsion after the polymerisation and before or during the distillation of
- 30 water from the emulsion.
3. A process according to claim 1 or claim 2 in which the amount of the volatile solvent utilised for washing the substantially dry emulsion or the polymer particles separated from the dry emulsion is from 85 to 99%, preferably 90 to 98%, based on the weight of solvent and
- 35 polymer.

4. A process according to any preceding claim in which the amount of the volatile solvent in the slurry or cake which is subjected to the evaporation is at least 50% by weight based on the weight of solvent and polymer.
- 5 5. A process according to any preceding claim in which the volatile solvent is isopropyl alcohol.
6. A process according to any preceding claim in which the concentration of monomer in the emulsion is below 70% by weight based on the weight of monomer and water and the  
10 emulsion contains 35 to 55% by weight of the monomer, 20 to 45% by weight of the volatile non-aqueous liquid and 20 to 40% by weight of the water, all based on the weight of monomer, volatile non-aqueous liquid and water.
- 
- 15 7. A powdered composition formed of particles, or aggregates of particles, of a polymer wherein the product can dissolve or swell in water to form a gel, characterised in that the particles have the characteristic, substantially spherical, shape of polymer particles made by reverse phase emulsion polymerisation and the composition  
20 gives a 0.5% gel in water at a gelling pH wherein the gel clarity is at least 90% at 430nm.
8. A product or process according to any preceding claim in which the polymer is a cationic polymer.
9. A product or process according to any preceding claim  
25 in which the cationic polymer is a cationic polymer of 50 to 100 mole percent of a water soluble cationic ester of methacrylic acid, 0 to 50 mole percent other water soluble ethylenically unsaturated monomer, and optionally cross linking agent, and in which the polymer is preferably a  
30 cross linked homopolymer of the methyl chloride quaternary salt of dimethylaminoethyl methacrylate.
10. A personal care composition thickened by a composition made by a process according to claim 1 or a product according to claim 9.



## A B S T R A C T

Polymeric Compositions and their  
Production and Uses

5

A clear personal care or other aqueous gel is formed from dry polymer particles which are free of materials which render the gel cloudy and which are made by reverse phase emulsion polymerisation. The polymerisation process involves distilling water from the emulsion in the presence of sufficient non-aqueous liquid to prevent breakage of the emulsion and then washing the polymer particles with isopropanol or other suitable solvent and evaporating the solvent.

15

**This Page is Inserted by IFW Indexing and Scanning  
Operations and is not part of the Official Record**

**BEST AVAILABLE IMAGES**

Defective images within this document are accurate representations of the original documents submitted by the applicant.

Defects in the images include but are not limited to the items checked:

- ☐ **BLACK BORDERS**
- ☐ **IMAGE CUT OFF AT TOP, BOTTOM OR SIDES**
- ☐ **FADED TEXT OR DRAWING**
- ☐ **BLURRED OR ILLEGIBLE TEXT OR DRAWING**
- ☐ **SKEWED/SLANTED IMAGES**
- ☐ **COLOR OR BLACK AND WHITE PHOTOGRAPHS**
- ☐ **GRAY SCALE DOCUMENTS**
- ☒ **LINES OR MARKS ON ORIGINAL DOCUMENT**
- ☐ **REFERENCE(S) OR EXHIBIT(S) SUBMITTED ARE POOR QUALITY**
- ☐ **OTHER:** \_\_\_\_\_

**IMAGES ARE BEST AVAILABLE COPY.**

**As rescanning these documents will not correct the image problems checked, please do not report these problems to the IFW Image Problem Mailbox.**